

Work Order ID 156106

Thursday, January 26, 2017 10:37:40 AM

156106

Page 1

Item ID: D2576-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step (Casting Detail)
Start Date: 1/31/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 2/14/2017 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JAN 26 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-88 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2576	Rev G								

100 PURCHASING 0.00 50 FEB 02 2017 DAS 13 9-89
100
Purchasing
Purchasing
Memo 0.00
Issue P/O: 35179 Cast per D2576-1 Pattern vendor: Alpine Non-Ferrous Material Release Note Required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
Packaging
Packaging
Memo 0.17
Ensure D2576 mould is returned with the ordered parts Ensure release note is attached
50x SP1703-3

120 QC6- Inspect dimensions to drawing 0.00
120
QC
Quality Control
Memo 0.00
50 DAS 38 9-89 MAR 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Thursday, January 26, 2017 10:37:43 AM

Page 1

Work Order ID: 156106

156106

Parent Item: D2576-1

D2576-1

Parent Item Name: Step (Casting Detail)

Start Date: 1/31/2017

Required Date: 2/14/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: A New Issue 05-11-29 JLM
IPP rev B rev F dwg 07.07.06 EC
IPP Rev:C As per Rev G 07-09-05 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2576-1P		Purchased	No			100	Each	0.0000	1	50			
D2576-1P									**				
Step (Casting Detail)													

50x SP17-03-3

DQA: _____ Date: _____



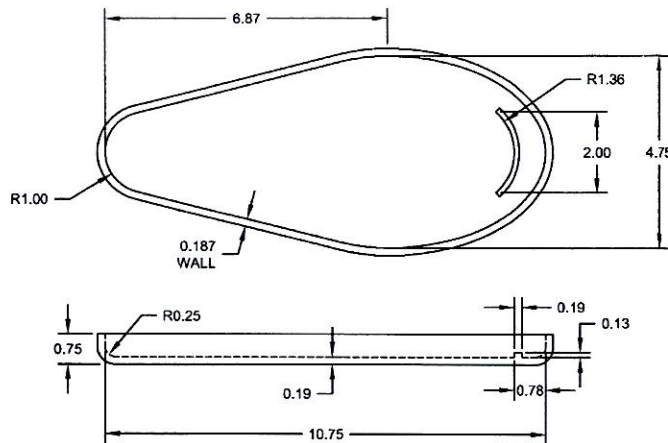
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

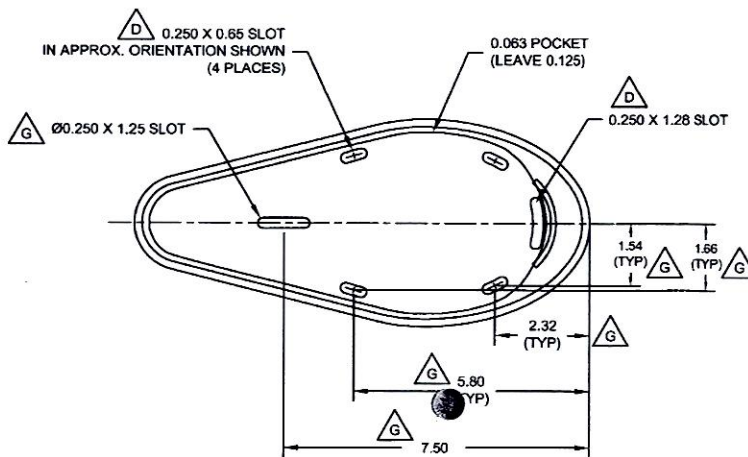
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							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 156106 MJS
17-01-26

RELEASED

07.08.21

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2576	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP	1:3
DATE	07.08.15	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35179**

Purchase Order Date 2/2/2017 10:09:52 AM
PO Print Date 2/2/2017

Page Number 1 of 2

Order From :

VC-ALP001

Ship To : DART AEROSPACE LTD

ALPINE NON-FERROUS FOUNDRY
8657 - 132ND STREET
SURREY, BC V3W 4P1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FEB 02 2017

Contact Name

Vendor Phone 604 596 8080

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2576-1P AS PER DWG D2576 REV. G B156106	Step (Casting Detail)	2/27/2017 Yes 2/27/2017		50.00 Each	\$17.75	\$887.50
Line Total:							\$887.50
2	71401-45	Procurement Quality Clause	2/27/2017 No 2/27/2017		1.00	\$0.00	\$0.00
PROCUREMENT QUALITY CLAUSES A004 FAA-PMA/TSO A005 RIGHT OF ENTRY A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

SP17-03-3

Note:

2/2/2017

8657-132ND STREET
SURREY, B.C. V3W 4P1
CANADA

PACKING LIST
~~WORK ORDER~~

Order No.: PO35179
Date: 02 Feb, 2017
Page: 1
Ship Date: 27 Feb, 2017

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

DART AEROSPACE

Order Date	Purchase Order#	Due Date	Ship Via	Page
02 Feb, 2017	PO35179	27 Feb, 2017	FEDEX	1
Item No.	Description	Ordered	Backorder quantity	Shipped quantity
DART D2576 ✓	D2576 STEP CSTG GS - GST @ 5% GST PST Exempt: #6122-5207	50	✓	50

2017-03-3

38

9-89

ALPINE NON-FERROUS FOUNDRY GST: #87550 0001

Comment: Castings&Patterns are property of Alpine until paid in full

SIEMEX CORPORATION
8F, No. 110, Sec. 2, Keelung Road,
Taipei City 10695, Taiwan, R. O. C.

CERTIFICATE OF ANALYSIS

Alloy: 535.2

Heat # 105091601~05

	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn
	%	%	%	%	%	%	%	%
1	0.0423	0.0817	0.0011	0.149	7.09	0.0021	0.0038	< 0.00060
2	0.0402	0.0826	0.0011	0.162	6.98	0.0020	0.0044	< 0.00060
3	0.0339	0.0775	0.0010	0.151	6.91	0.0020	0.0037	< 0.00060
4	0.0329	0.0728	0.0103	0.136	6.82	0.0021	0.0031	< 0.00060
5	0.0343	0.0844	0.00033	0.141	6.89	0.0020	0.0038	< 0.00060

	Ti	Ca	Na	Pb	Sb	Sn	Sr	Al
	%	%	%	%	%	%	%	%
1	0.139	< 0.00010	0.00072	0.0021	< 0.00040	0.00073	< 0.00010	92.5
2	0.170	< 0.00010	0.00032	0.0021	< 0.00040	0.00087	< 0.00010	92.6
3	0.142	< 0.00010	0.00018	0.0021	< 0.00040	0.00059	< 0.00010	92.7
4	0.136	< 0.00010	0.00016	0.0020	< 0.00040	< 0.00050	< 0.00010	92.8
5	0.136	< 0.00010	0.00018	0.0020	< 0.00040	0.00063	< 0.00010	92.7